

# Work Order ID 60089

June 24, 2010 9:13:50 AM



Page 1

Item ID: D3262-5

Accept



Setup

Start



Revision ID:

Item Name: Cap

Stop



Start Date: 6/24/10 Start Qty: 6.00

Required Date: 7/02/10 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

*Ref 10-25*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3262

E

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.000" x 0.500" x 5.400" long Bar

*MU= 10/06/09*

*6 0*

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per dwg D3262  
Machine as per Folio FA902 and Dwg D3262  
FOLIO REV: *10/07/4*  
DWG REV: *10/07/4*  
TAP USING JIG DT9636  
Deburr

*MU= 10/07/4*

*6 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60089

June 24, 2010 9:13:50 AM



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Item ID: D3262-5

Accept



Setup

Start



Revision ID:

Item Name: Cap

Stop



Start Date: 6/24/10

Start Qty: 6.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*mf*  
*10/07/04*

*6*

*2*

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*mf*  
*10/07/05*

*6*

*2*

140

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

*Barclay*

*10/07/05 (6)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60089**

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Item ID: D3262-5

Revision ID:

Item Name: Cap

Start Date: 6/24/10

Start Qty: 6.00

Required Date: 7/02/10

Req'd Qty: 6.00

Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

C21017105

10-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:13:49 AM

Page 1

Work Order ID: 60089

Parent Item: D3262-5

Parent Item Name: Cap



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP  
Rev:B as per ECN10-571 DD 10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	31.1445	0.96	6.063158			



6061-T6 Bar .500 x 6.00



Location

Loc Qty

Loc Code

MAT05

31.1445

110912

0.5945

112567

30.55

~~2.835~~ (6 piece) mms  
576 10/06/29  
JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	60029
<b>Description: Cap</b>		<b>Part Number:</b>	D3262-5
<b>Inspection Dwg: D3262</b>	<b>Rev: E</b>	Page 1 of 1	

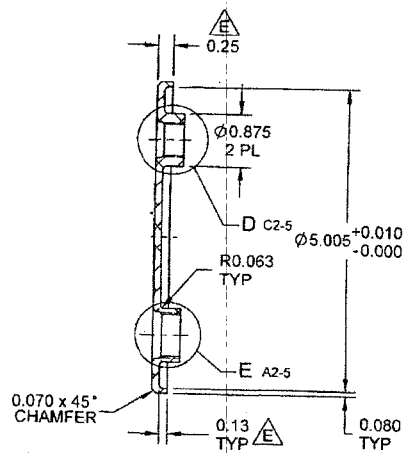
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	.436	✓			
0.25	+/-0.030	.247	✓			
Ø0.875	+/-0.010	.875	✓			
Ø5.005	+0.010/-0.000	5.006	✓			
R0.063	+/-0.010	.063	✓			
0.080	+/-0.010	.078	✓			
0.13	+/-0.030	.130	✓			
0.070 x 45°	+/-0.010 x 0.5°	.070 x 45°	✓			
Ø5.165 Ref	+/-0.010	5.167	✓			
1.63	+/-0.030	1.624	✓			
3.25 Ref	+/-0.030	3.248	✓			
9/16-18 UNF-3B	N/A	9/16-18	✓			
3/4-16 UNF-3B	N/A	3/4-16	✓			
0.091	+0.007/-0.008	.097	✓			
R0.03	+/-0.010	.03	✓			
R0.02	+0.00/-0.01	.02	✓			
45°	+/-0.5°	45°	✓			
30°	+/-0.5°	30°	✓			
Ø0.588	+0.005/-0.000	Ø.593	✓			
Ø0.696	+0.007/-0.008	Ø.692	✓			
0.101	+0.008/-0.007	.104	✓			
R0.03	+/-0.010	Ø.03	✓			
R0.02	+0.00/-0.01	Ø.02	✓			
45°	+/-0.5°	45°	✓			
30°	+/-0.5°	30°	✓			
Ø0.771	+0.005/-0.000	Ø.774	✓			
Ø0.882	+0.008/-0.007	Ø.881	✓			

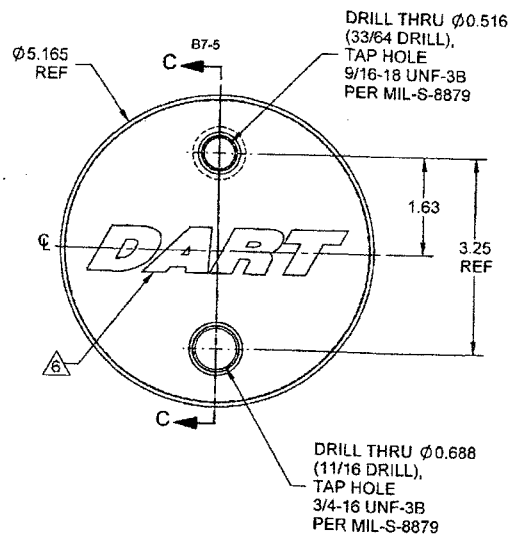
<b>Measured by:</b>	MJF	<b>Audited by:</b>	CMJ	<b>Preliminary Approval:</b>	
<b>Date:</b>	10/07/04	<b>Date:</b>	10/07/05	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

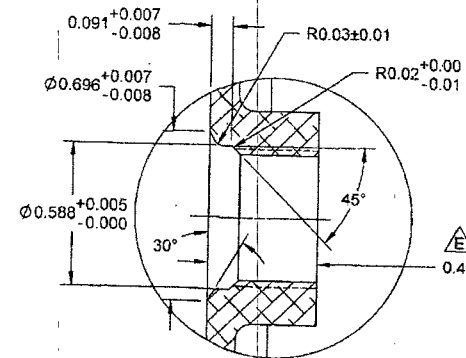
w/o 60089



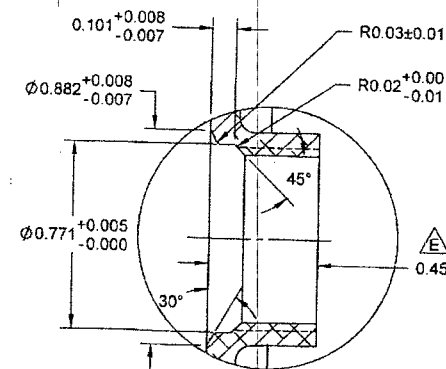
SECTION C-C D5-5



D3262-5 CAP



DETAIL D C7-5  
SCALE 2X



DETAIL E B7-5  
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	RF	DRAWING NO.
MFG. APPR.	RF	D3262
APPROVED	RF	TITLE
DE APPR.	RF	FUEL PURGE CANISTER
DATE	10.05.03	REV. E
		SHEET 5 OF 5
		SCALE
		NTS

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RELEASED  
R 2010-05-27  
NN